

Page 1

Setup Start *NCS*

NCS
Stop

Customer:

NB1

NB

Photocopyy bluefille & create labels per PPP D412-630-034 CHG005

Das
36

Assemble as per dwg D412-630 p.14
Coat all hardware with LPS3 rust inhibitor
A/R LPS3 batch: 183737
COAT exposed HARDWARE WITH LPS PROCYON.
A/R LPS PROCYON BATCH: 136690



DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐		AGAINST DEPARTMENT/PROCESS		MRB (QSI042) Approval	
Date: _____ Step #: _____		QTY Effective : _____					
Description Work Order Deviation							
		Disposition					
		Completed By					
		Lead hand / Supervisor Approval Verification					
		QC / QA Coordinator Approval					

Root Cause		FAULT CATEGORY									
Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong						
Design	Operator	Bending	Set-up	Folio/Program	Outside Dimensions						
Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance						
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect						
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing						
Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved						
Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing						
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish						
LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread						
Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence						
Past Expiry Date	Manufacturing Process										
Misidentified	Past Due										
		OTHER : _____									

Date: 16.08.29

2ART
AEROSPACE

Work Order update only

[illegible]

Work Order ID 148964

Tuesday, July 12, 2016 11:26:24 AM

148964

Item ID: D412-630-034

Accept

Revision ID:

N900040100

Setup Start

NS1

Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Stop

NS2

Start Date: 7/12/2016

Start Qty: 3.00

3

Cust Item ID:

Required Date: 7/15/2016

Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.01

Quality Control

JUL 15 2016

130

Pick Kit

0.00

130

Packaging

Memo

0.00

Packaging

JUL 12 2016

140

QC4- 100% Inspect kits for completeness

0.00

140

QC

Memo

0.02

Quality Control

JUL 15 2016

DQA: _____ Date: _____

Date:

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Date:

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Supplier ☐			
Date : _____		Step #: _____		QTY Effective : _____			
Description Work Order Deviation		Disposition		MRB (QSI042) Approval			
_____		_____		Completed By			
_____		_____		Lead hand / Supervisor Approval Verification			
_____		_____		QC / QA Coordinator Approval			

Root Cause		FAULT CATEGORY									
Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong						
Design	Operator	Bending	Set-up	Folio/Program	Outside Dimensions						
Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance						
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect						
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing						
Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved						
Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing						
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish						
LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread						
Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence						
Past Expiry Date	Manufacturing Process										
Misidentified	Past Due										

OTHER : _____

Work Order ID 148964
Tuesday, July 12, 2016 11:26:24 AM

148964

Page 3

Item ID: D412-630-034
Revision ID:

Accept

N9000040100

Setup Start

NS1

Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Stop

NS2

Start Date: 7/12/2016 Start Qty: 3.00

3

Cust Item ID:

Required Date: 7/15/2016 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

NR1

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

15N

Packaging

Packaging

Memo

Packaging

Identify and pack for shipping as per PPP D412-630-034
Location: _____
PPP Rev: _____

X1 Sold
BK003 X2

JUL 15 2016

160

16N

QC

QC21 - Final Inspection - Work Order Release

0.00

Memo

0.05

Quality Control

DAS
21
9-69 JUL 15 2016

8cm 16/07/2015



DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS									
Part No. _____		Rework Scrap Use-as-is Suspected Unapproved		Cross tube Small Fab Finishing Composite		Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier		Engineering Quality Other					
NCR No. _____				Skid-tube Machining Thermoforming Large Fab									
Date: _____		Step #: _____		QTY Effective: _____				MRB (QSI042) Approval					
Description Work Order Deviation				Disposition									
										Completed By			
										Lead hand / Supervisor Approval Verification		QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY									
Environment		No Re-verification		Pressure/Forced		Temperature/Cure		Power Loss/Surge		Positioned Wrong			
Design		Operator		Bending		Set-up		Folio/Program		Outside Dimensions			
Doc/Data		Offset/Setup		Centre Not Concentric		BOM/Route		Grain		Over/Under tolerance			
Equip/Tooling		Supplier		Cracks		Broken/Damage/Defect		Weld		Part Incorrect			
Handling/Pre		Training		Crimp/Kink/Ripple/Wave		Inspection Incomplete/Unqualified		Wrong Stock Pulled		Part Lost/Missing			
Material		Use for Testing		Cuffs		Contamination		Out of Sequence		Part Moved			
Internal Transport		Poor Information		Crushing		Countersink		Off-set		Drawing			
Tribal Knowledge		Rushing		Heat Treat		Cut Too Short		Mislabeled		Finish			
LOA		Product Improvement		Wave/Twist in Tube		Instructions Incomplete/Unclear		Fit/Function		Misread			
Substation		Process Improvement		Marks/Chatter				Misaligned/off center		Turning Sequence			
Past Expiry Date		Manufacturing Process											
Misidentified		Past Due											
				OTHER: _____									

Picklist Print

Tuesday, July 12, 2016 11:26:23 AM

Work Order ID: 148964

Parent Item: D412-630-034

Parent Item Name: Folding Heil-Access-Step™ RH - Low, High & Float Gear

148964

D412-630-034

Start Date: 7/12/2016
Start Qty: 3.00
Required Date: 7/15/2016
Required Qty: 3.00

Comments:

IPP Rev:A New Issue 06-11-08 JLM
IPP rev B ecn1019, added D2807-041 EC verified by:DD
IPP rev :C 11.01.06 added route seq ID DD vef:BC IPP REV:D
13.06.07 PER CHG004 DD vef:JLM IPP REV:E 16.06.23 AS
PER IIN REV.O DD VEF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN310C8
AN310C8
Nut

AN3C21A

AN3C21A
Bolt

Purchased	No	110	Each	16.0000	2	6							
**													
<u>Location</u>													
ST331			16										
m132677			16										
Purchased	No	110	Each	27.0000	1	3							
**													
<u>Location</u>													
OVER002			25										
M133686			25										
ST348			2										
M133640			2										

11/12/2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐	AGAINST DEPARTMENT/PROCESS	Step #: _____ QTY Effective : _____	MRB (QS1042) Approval
Description Work Order Deviation		Disposition		
Completed By		Lead hand / Supervisor Approval Verification		
QC / QA Coordinator Approval		Fault Category		

Root Cause		Fault Category									
Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong						
Design	Operator	Bending	Set-up	Folio/Program	Outside Dimensions						
Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance						
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect						
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing						
Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved						
Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing						
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish						
LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread						
Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence						
Past Expiry Date	Manufacturing Process										
Misidentified	Past Due										
OTHER :											

Picklist Print

Tuesday, July 12, 2016 11:26:23 AM

Work Order ID: 148964

Parent Item: D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

148964

D412-630-034

Start Date: 7/12/2016

Start Qty: 3.00

Required Date: 7/15/2016

Required Qty: 3.00

AN8C16

Purchased

No

110

Each

51.0000

2

6

AN8C16

Bolt

**

9 6 6 6

Location

Loc Qty

Loc Code

over005

35

M133091

7

M133336

7

M133920

7

M133921

7

M134131

7

ST332

16

131651

2

M132522

7

M132674

7

9 6 6 6

D2012-107

Manufactured

No

110

Each

16.0000

1

3

D2012-107

Clevis

**

Location

Loc Qty

Loc Code

WA004

16

145274

16

Manufactured

No

110

Each

3.0000

1

3

9 6 6 6

D2803-042

D2803-042

Bracket Assembly

**

Location

Loc Qty

Loc Code

ST473

3

148432

3

3

JUL 12 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐	AGAINST DEPARTMENT/PROCESS	Step #: _____ QTY Effective : _____ Disposition 	MRB (QS1042) Approval
Description Work Order Deviation				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____

Root Cause				FAULT CATEGORY											
Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong	Outside Dimensions	Over/Under tolerance	Part Incorrect	Part Lost/Missing	Part Moved	Drawing	Finish	Misread	Turning Sequence	
Design	Operator	Bending	Set-up	Folio/Program											
Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grain											
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld											
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled											
Material	Use for Testing	Cuffs	Contamination	Out of Sequence											
Internal Transport	Poor Information	Crushing	Countersink	Off-set											
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled											
LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function											
Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center											
Past Expiry Date	Manufacturing Process														
Misidentified	Past Due														
OTHER : _____															

Picklist Print

Tuesday, July 12, 2016 11:26:23 AM

Work Order ID: 148964

Parent Item: D412-630-034

Parent Item Name: Folding Heli-Access Step™ RH - Low, High & Float Gear

148964

D412-630-034

Start Date: 7/12/2016

Start Qty: 3.00

Required Date: 7/15/2016

Required Qty: 3.00

D2804-042

Manufactured No

110 Each

3.0000

1 3

D2804-042

RH Step Fwd Bracket

**

9.6.15

Location
ST475

Loc Qty
3

Loc Code

148425

Manufactured No

110 Each

15.0000

2 6

D2807-041

Prop Assembly

**

9.6.15

Location

Loc Qty

Loc Code

FG 89606

2

STD10

2

142559

13

142559

13

142559

13

110 Each

30.0000

2 6

9.6.15

142559

13

110 Each

30.0000

2 6

9.6.15

142559

13

110 Each

30.0000

2 6

9.6.15

142559

13

110 Each

30.0000

2 6

9.6.15

142559

13

110 Each

30.0000

2 6

9.6.15

142559

13

110 Each

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110 Each

30.0000

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13

110 Each

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110 Each

30.0000

2 6

9.6.15

142559

13

110 Each

30.0000

2 6

9.6.15

142559



DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS									
		Rework Scrap Use-as-is Suspected Unapproved		Skid-tube Machining Thermoforming Large Fab		Cross tube Small Fab Finishing Composite		Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier		Engineering Quality Other			
Date: _____		Step #: _____		QTY Effective: _____		MRB (QSI042) Approval							
Description Work Order Deviation				Disposition									
												Completed By	
												Lead hand / Supervisor Approval Verification	
												QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY									
Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong								
Design	Operator	Bending	Set-up	Folio/Program	Outside Dimensions								
Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance								
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect								
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing								
Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved								
Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing								
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish								
LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread								
Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence								
Past Expiry Date	Manufacturing Process												
Misidentified	Past Due												
				OTHER: _____									

Picklist Print

Tuesday, July 12, 2016 11:26:23 AM

Work Order ID: 148964

148964

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 7/12/2016

Required Date: 7/15/2016

Start Qty: 3.00

Required Qty: 3.00

D3562-042

Manufactured

No

110 Each

1.0000

1 3

D3562-042

Step Weldment

Location

Loc Qty

Loc Code

FG039

142348

110 Each

1,140.000

4 12

Purchased

No

MS21043-3

Nut

Location

Loc Qty

Loc Code

FG

103691

FF001

m130673

GA

m133990

OVER007

m135058

ST302

m134861

ST304

m131340

Purchased

No

110 Each

44.0000

2 6

MS24665-302

Cotter Pin

Location

Loc Qty

Loc Code

GA

120521

ST288

m134738

110 Each

44.0000

2 6

JUL 12 2016

DAS 6 8-69

DAS 6 8-69

16/07/13 DAS 36 9-69

B146526 (36)

Date:

Date:

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved		AGAINST DEPARTMENT/PROCESS ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other				Date : _____ Step #: _____		MRB (QS1042) Approval	
Description Work Order Deviation				Disposition							
Completed By				Lead hand / Supervisor Approval Verification							
								QC / QA Coordinator Approval			
Root Cause				FAULT CATEGORY							
Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong	Outside Dimensions	Over/Under tolerance				
Design	Operator	Bending	Set-up	Folio/Program	Drawing	Part Lost/Missing	Part Moved				
Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Off-set	Part Lost/Missing	Drawing				
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Misaligned	Part Lost/Missing	Finish				
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Fit/Function	Misread	Turning Sequence				
Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Misaligned/off center						
Internal Transport	Poor Information	Crushing	Countersink	Off-set							
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Misaligned							
LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function							
Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center							
Past Expiry Date	Manufacturing Process										
Misidentified	Past Due										
OTHER :											

Picklist Print

Tuesday, July 12, 2016 11:26:23 AM

Work Order ID: 148964

148964

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 7/12/2016

Required Date: 7/15/2016

Start Qty: 3.00

Required Qty: 3.00

MS24693-C280

Purchased

No

110

Each

23.0000

2

6

MS24693-C280

SCREW

**

DAS 6

9.69

Location
ST287

Loc Qty
23

Loc Code
23

m131624

110

Each

36.0000

1

3

DAS 6

MS24693-C285

Purchased

No

**

DAS 6

9.69

MS24693-C285

Screw

Location
ST287

Loc Qty
36

Loc Code
36

m134558

130

Each

17.0000

1

3

DAS 6

9.69

AN44C7A

Purchased

No

**

DAS 6

9.69

AN44C7A

Eyebolt

DAS 27

9.69

Location
ST339

Loc Qty
17

Loc Code
17

m134502

130

Each

13.0000

1

3

DAS 6

9.69

AN4C10A

Purchased

No

**

DAS 6

9.69

AN4C10A

BOLT

Location
ST345

Loc Qty
13

Loc Code
13

M131153

130

Each

13.0000

1

3

DAS 6

9.69

DAS 27

9.69

JUL 12 2016

Date:

Date:

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved		AGAINST DEPARTMENT/PROCESS ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other		MRB (QS1042) Approval					
Date : _____		Step #: _____		QTY Effective : _____		MRB (QS1042) Approval					
Description Work Order Deviation				Disposition							
Completed By				Lead hand / Supervisor Approval Verification							
								QC / QA Coordinator Approval			

Root Cause		FAULT CATEGORY											
Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong								
Design	Operator	Bending	Set-up	Folio/Program	Outside Dimensions								
Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance								
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect								
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing								
Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved								
Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing								
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish								
LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread								
Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence								
Past Expiry Date	Manufacturing Process												
Misidentified	Past Due												
OTHER :													

Picklist Print

Tuesday, July 12, 2016 11:26:23 AM

Work Order ID: 148964

Parent Item: D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

148964

D412-630-034

Start Date: 7/12/2016

Required Date: 7/15/2016

Start Qty: 3.00

Required Qty: 3.00

AN4C15A

Purchased

No

130

Each

158,0000

2

6

AN4C15A

Bolt

DAS 6 9-89

DAS 27 9-89

**

DAS 6 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

FG

120360

10

10

OVER002

M132763

50

20

M133485

30

98

ST343

M130716

40

M131377

24

M132189

16

M132680

4

M132823

14

130

Each

487,0000

1

3

**

DAS 6 9-89

DAS 27 9-89

**

DAS 6 9-89

DAS 27 9-89

**

DAS 6 9-89

DAS 27 9-89

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DAS 6 9-89

DAS 27 9-89

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DAS 27 9-89

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DAS 6 9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____	Step #: _____	QTY Effective : _____	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; text-align: center;"> <tr> <td>Skid-tube Machining</td> <td>Cross tube Small Fab</td> <td>Water Jet Prod. Eng. Coord.</td> <td>Engineering Quality</td> </tr> <tr> <td>Thermoforming Large Fab</td> <td>Finishing Composite</td> <td>Rec/Store/Packaging Supplier</td> <td>Other</td> </tr> </table>	Skid-tube Machining	Cross tube Small Fab	Water Jet Prod. Eng. Coord.	Engineering Quality	Thermoforming Large Fab	Finishing Composite	Rec/Store/Packaging Supplier	Other	MRB (QS1042) Approval
Skid-tube Machining	Cross tube Small Fab	Water Jet Prod. Eng. Coord.	Engineering Quality									
Thermoforming Large Fab	Finishing Composite	Rec/Store/Packaging Supplier	Other									
Description Work Order Deviation			Disposition									
Completed By			Lead hand / Supervisor Approval Verification									
QC / QA Coordinator Approval			QC / QA Coordinator Approval									

FAULT CATEGORY											
Root Cause		Temperature/Cure				Power Loss/Surge				Positioned Wrong	
Environment	No Re-verification	Pressure/Forced	Set-up	Folio/Program	Grain	Outside Dimensions	Over/Under tolerance	Part Incorrect	Part Lost/Missing	Part Moved	Drawing
Design	Operator	Bending	BOM/Route	Weld	Wrong Stock Pulled	Out of Sequence	Off-set	Mislabeled	Fit/Function	Misread	Turning Sequence
Doc/Data	Offset/Setup	Centre Not Concentric	Broken/Damage/Defect	Inspection Incomplete/Unqualified	Contamination	Countersink	Cut Too Short	Instructions Incomplete/Unclear	Drill Holes		
Equip/Tooling	Supplier	Cracks	Crimp/Kink/Ripple/Wave	Cuffs	Crushing	Heat Treat	Wave/Twist in Tube	Marks/Chatter			
Handling/Pre	Training	Use for Testing	Poor Information	Rushing	Product Improvement	Process Improvement	Manufacturing Process	Past Due			
Material	Internal Transport	Tribal Knowledge	LOA	Substation	Past Expiry Date	Misidentified					
							OTHER :				

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐		AGAINST DEPARTMENT/PROCESS		MRB (QS1042) Approval	
Date: _____ Step #: _____		QTY Effective: _____					
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor Approval Verification			
				QC / QA Coordinator Approval			

Root Cause		FAULT CATEGORY									
Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong						
Design	Operator	Bending	Set-up	Folio/Program	Outside Dimensions						
Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance						
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect						
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing						
Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved						
Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing						
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish						
LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread						
Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence						
Past Expiry Date	Manufacturing Process										
Misidentified	Past Due										
		OTHER: _____									

Picklist Print

Tuesday, July 12, 2016 11:26:23 AM

Work Order ID: 148964

148964

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 7/12/2016

Required Date: 7/15/2016

Start Qty: 3.00

Required Qty: 3.00

D3396-1

Manufactured

No

130

Each

18.0000

2

6

D3396-1

Spacer

Location

Loc Qty

Loc Code

ST034

142351

130

Each

261.0000

5

15

D3672-15

Manufactured

No

130

Each

261.0000

5

15

D3672-15

Phenolic Washer

Location

Loc Qty

Loc Code

ST050

148073

130

Each

400.0000

7

21

D3672-17

Manufactured

No

130

Each

400.0000

7

21

D3672-17

Phenolic Washer

Location

Loc Qty

Loc Code

ST050

148074

130

Each

440.0000

4

12

D3672-19

Manufactured

No

130

Each

440.0000

4

12

D3672-19

Phenolic Washer

Location

Loc Qty

Loc Code

ST050

148075

130

Each

440.0000

4

12

DAS
27
9-89

DAS
6
9-89

DAS
6
9-89

DAS
6
9-89

DAS
6
9-89

DAS
6
9-89

JUL 12 2016

DQA:

Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Large Fab ☐ Composite ☐ Supplier ☐				Engineering ☐ Quality ☐ Other ☐		MRB (QS1042) Approval	
Date: _____		Step #: _____		QTY Effective : _____		Disposition					
Description Work Order Deviation										Completed By	
										Lead hand / Supervisor Approval Verification	
										QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY											
Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong										
Design	Operator	Bending	Set-up	Folio/Program	Outside Dimensions										
Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance										
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect										
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing										
Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved										
Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing										
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish										
LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread										
Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence										
Past Expiry Date	Manufacturing Process														
Misidentified	Past Due														
OTHER :															

Picklist Print

Tuesday, July 12, 2016 11:26:23 AM

Work Order ID: 148964

148964

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 7/12/2016

Required Date: 7/15/2016

Start Qty: 3.00

Required Qty: 3.00

Manufactured

No

130

Each

664.0000

7

21

**

D3672-5

Washer, Phenolic

Location

Loc Qty

Loc Code

FG

44679

8

ST049

35521

23

44679

23

ST051A

50354

380

Manufactured

No

130

Each

974.0000

4

12

**

D3672-7
D3672-7

Washer, Phenolic

Location

Loc Qty

Loc Code

FG

129987

40

133986

25

ST049

134786

15

142572

434

ST051A

147220

3

431

500

500

500

500

500

500

500

500

500

500

500

500

500

500

500

500

500

500

500

500

D3672-7

M142572

(110)

12x

16/07/13

DAS 36 9-89

D3672-15

M148073

(110)

15x

16/07/13

DAS 36 9-89

D3672-19

M148075

(110)

12x

16/07/13

DAS 36 9-89

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved		AGAINST DEPARTMENT/PROCESS ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other			
Date : _____		Step #: _____		QTY Effective : _____			
Description Work Order Deviation		Disposition		MRB (QS1042) Approval			
Completed By		Lead hand / Supervisor Approval Verification		QC / QA Coordinator Approval			

Root Cause		FAULT CATEGORY									
Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong						
Design	Operator	Bending	Set-up	Folio/Program	Outside Dimensions						
Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance						
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect						
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing						
Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved						
Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing						
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish						
LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread						
Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence						
Past Expiry Date	Manufacturing Process										
Misidentified	Past Due										
		OTHER :									

Picklist Print

Tuesday, July 12, 2016 11:26:23 AM

Work Order ID: 148964

148964

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 7/12/2016

Required Date: 7/15/2016

Start Qty: 3.00

Required Qty: 3.00

MS21043-4

Purchased

No

130

Each

1,039,000

4

12

MS21043-4

Nut

DAS 26 9.89
DAS 6 9.89
DAS 26 9.89

Location

Loc Qty

Loc Code

FG

104603

40

40

17

17

17

17

17

17

17

17

17

17

17

17

GA

m132803

300

300

300

300

300

300

300

300

300

300

300

300

300

300

OVER007

m134754

300

300

300

300

300

300

300

300

300

300

300

300

300

300

ST302

m133769

12

12

12

12

12

12

12

12

12

12

12

12

12

12

m134502

m134634

70

70

70

70

70

70

70

70

70

70

70

70

70

70

m134943

300

300

300

300

300

300

300

300

300

300

300

300

300

300

300

MS21043-5

Purchased

No

130

Each

213,0000

3

9

MS21043-5

Nut

DAS 26 9.89
DAS 6 9.89
DAS 26 9.89

Location

Loc Qty

Loc Code

FG

101418

20

20

20

20

20

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20

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20

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20

20

GA

116548

76

76

76

76

76

76

76

76

76

76

76

76

76

76

ST302

m132382

9

9

9

9

9

9

9

9

9

9

9

9

9

9

m134502

m135157

8

8

8

8

8

8

8

8

8

8

8

8

8

8

m135157

100

100

100

100

100

100

100

100

100

100

100

100

100

100

100

DQA:

Date: _____

QA Closed:

Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only



Work Order: _____		AGAINST DEPARTMENT/PROCESS		Engineering	
Part No. _____		Cross tube		Water Jet	
NCR No. _____		Skid-tube		Prod. Eng. Coord.	
Date: _____		Machining		Rec/Store/Packaging	
Step #: _____		Thermoforming		Supplier	
Description Work Order Deviation		QTY Effective: _____		MRB (QS1042) Approval	
Disposition		Completed By		Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY		QC / QA Coordinator Approval	
Environment	No Re-verification	Temperature/Cure	Power Loss/Surge	Positioned Wrong	
Design	Operator	Set-up	Folio/Program	Outside Dimensions	
Doc/Data	Offset/Setup	BOM/Route	Grain	Over/Under tolerance	
Equip/Tooling	Supplier	Broken/Damage/Defect	Weld	Part Incorrect	
Handling/Pre	Training	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing	
Material	Use for Testing	Contamination	Out of Sequence	Part Moved	
Internal Transport	Poor Information	Countersink	Off-set	Drawing	
Tribal Knowledge	Rushing	Cut Too Short	Mislabeled	Finish	
LOA	Product Improvement	Instructions Incomplete/Unclear	Fit/Function	Misread	
Substation	Process Improvement	Drill Holes	Misaligned/off center	Turning Sequence	
Past Expiry Date	Manufacturing Process				
Misidentified	Past Due				
OTHER: _____					

Work Order ID 148964

Tuesday, July 12, 2016 11:26:24 AM

prime only

Item ID: D412-630-034

Accept

N9000040100

Setup Start

NS1

Revision ID:

Folding Heil-Access-Step™ RH - Low, High & Float Gear

Stop

NS2

Item Name:

Cust Item ID:

Start Date: 7/12/2016

Start Qty: 3.00

3

Customer:

Required Date: 7/15/2016

Req'd Qty: 3.00

3

Reference:

Run Start

NR1

Approvals:

Process Plan: *Den*

Date: 7/12/12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-630

Rev O

JUL 12 2016

100

Document Control

0.00

DOCUMENT CONTROL

0.00

100

Memo

DC

Photocopy bluefile & create labels per PPP D412-630-034 CHG005

Doc. Control -USB or Paperwork

110

Small Fab

0.00

110

Small Fab

Memo

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch:

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON BATCH:

0.17

Work Order ID 148964

Tuesday, July 12, 2016 11:26:24 AM

B711 *148964* prime only

Item ID: D412-630-034

Accept

N9900040100

Setup Start

N.S.1

Revision ID:

Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Cust Item ID:

Stop *N.S.2*

Start Date: 7/12/2016 Start Qty: 3.00

Required Date: 7/15/2016 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan: 800 Date: 7/12/12 Tooling: _____

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Tool ID Tool # Plan Code

Accept Qty

Reject Qty

Reject Number Insp. Stamp

Sequence ID/ Work Center ID

Draw Nbr

IIN D412-630

Rev O

JUL 12 2016

100

Document Control

0.00

DOCUMENT CONTROL

0.00

DC

Memo

Doc.Control -USB or Paperwork

Photocopy bluefile & create labels per PPP D412-630-034 CHG005

110

111N

Small Fab

Small Fab

Memo

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: _____

COAT exposed HARDWARE WITH LPS PROCYON

A/R LPS PROCYON BATCH: _____

DAS 21 JUL 13 2016

8-89

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
7	7			D3672-5	WASHER (OR NAS1515H5)
		4	4	D3672-7	WASHER (OR NAS1515H5L)
		5	5	D3672-15	WASHER (OR NAS1515H3)
7	7			D3672-17	WASHER (OR NAS1515H4)
		4	4	D3672-19	WASHER (OR NAS1515H8)
		1	1	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C65)
		1	1	MS24693-C285	SCREW (OR MS24694-C76)

